

Work Order ID 107002

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Friday, September 13, 2013 10:38:38 AM

Item ID: D4617-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Clamp Body
 Start Date: 9/13/2013 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 9/19/2013 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: MF Date: 13-9-13 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4617	B								
100	Cut blanks as per folio	0.00							
100									
Bandsaw	Memo 3,540	0.00							
Jeaspa Bandsaw									
110		0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	MILL AS PER DWG AND FOLIO FB111 FOLIO REV: <u>AA</u> DWG REV: <u>B</u> DEBURR								

12 0 13-9-24

12 0 JFC 2013-09-26

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Item ID: D4617-5 **D 4617-5** Accept ***N900040100*** Setup Start ***NS1***
Revision ID: **B 107002** Stop ***NS2***
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Required Date: 9/19/2013 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				12	0		JFC 2013-09-26
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		DAS 44 9-23 13/09/30		12	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				12		7613-10-2	

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				(12)			DAS 09
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>8T115</u> Memo	0.00 0.00				12x			DAS 09 13-10-7
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							HJ / Rm 13/10/07. H/13-10-7

Picklist Print

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Work Order ID: 107002

Parent Item: D4617-5

Parent Item Name: Clamp Body

Start Date: 9/13/2013

Required Date: 9/19/2013

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 12-04-13 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6B1.250X01.250

Purchased

No

f

39.5861

3.1578947

6061-T6 Bar 1.25 x 1.25

SL 13-9-24

Location

Loc Qty

Loc Code

MAT003

39.5861421

122521

0.6638421

123649

2.978

124443

13.5193

m126647

22.425

3.6

DART AEROSPACE LTD		Work Order: 107002
Description: clamp Body		Part Number: D4617-5
Inspection Dwg:	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.257	+0.006 - 0.001	0.261	✓		JFL	Gage pin (0.261)
1.000	± 0.010	1.000	✓			Caliper JFL-01
0.500	"	0.500	✓			"
2.810	"	2.813	✓			HG 31006
1.120	"	1.118	✓			Caliper JFL-01
0.560	"	0.560	✓			"
2.000	"	2.000	✓			"
Ø 0.753	-0.000 + 0.003	0.753	✓			(0.756) gage pin (0.753)
0.430	± 0.010	0.430	✓			Caliper JFL-01
0.060	"	0.060	✓			HG 31006
0.810	"	0.810	✓			Caliper JFL-01
1.690	"	1.690	✓			"
2.810	"	2.810	✓			"
3.340	"	3.341	✓			"
0.375	"	0.373	✓			"
1.000	"	1.000	✓			"
R0.375	"	R0.375	✓			HG 31006
0.257	+0.006 - 0.001	0.261	✓		JFL	Gage pin (0.261)

Measured by: JFL	Audited by: DAS AA 9-88	Preliminary Approval:
Date: 2013-09-26	Date: 13/09/30	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15